

Work Order ID 106505

Wednesday, September 04, 2013 2:16:58 PM

106505

Page 1

Item ID: PB67-43001-75

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Blade Support Ass'y

Start Date: 9/4/2013 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/13/2013 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *13-9-04* Tooling:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

B67-43001-75

Rev C

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

Weld assembly as per dwg PB67-43001

2 8

13-09-05

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

② 13-09-05

DAS
09
08

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

② 13-09-05

DAS
09
08



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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

Green Sandtex(Ref:4.3.5.8) per QS1005 4.3

0.00

130

Powdercoat

Memo

0.00

Powder Coating

1- put screws in nut plates before to keep thread clean
START TIME: 10:30 OVEN TEMPERATURE:

32021- FINISH TIME: 11:00

2x PM 13/09/10

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

2x d 13/09/10

150

Identify as per dwg & Stock Location: _____

0.00

150

Packaging

Memo

0.00

Packaging

MP 23/PA 2

3/3/10 (2)

M 111277

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106505

Page 3

Item ID: PB67-43001-75

Accept

N900040100Setup Start ***NS1***

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Start Date: 9/4/2013 Start Qty: 2.00

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Cust Item ID:

Required Date: 9/13/2013 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

13/9/11

B-0911

Picklist Print

Wednesday, September 04, 2013 2:16:57 P

Page 1

Work Order ID: 106505

Parent Item: PB67-43001-75

Start Date: 9/4/2013

Required Date: 9/13/2013

Parent Item Name: Upper Blade Support Ass'y

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-17 new issue DD verified by:ec IPP rev B 10.09.30 per rev C
dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3450-1 Reinforcement Plate		Manufactured	No			100	Each	13.0000	1	2		11/13/09.05	

Location	Loc Qty	Loc Code
ST372	13	
104517	11	
53302	2	

PB67-43001-167 Side Plate		Manufactured	No			100	Each	30.0000	2	4		11/13/09.05	
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Location	Loc Qty	Loc Code
Mezz2	24	
99997	24	
ST446	6	
92471	6	

PB67-43001-169 Long Support Plate		Manufactured	No			100	Each	16.0000	1	2		11/13/09.05	
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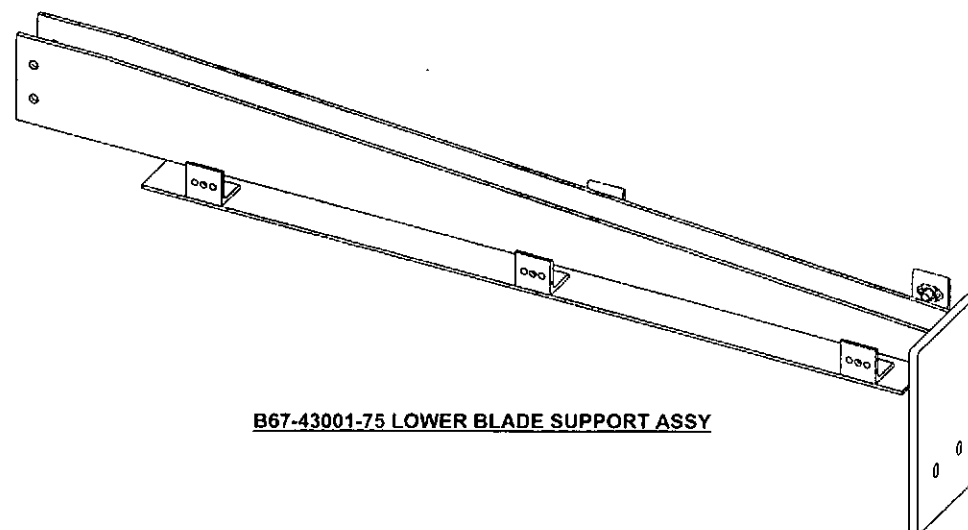
Location	Loc Qty	Loc Code
ST439	11	
99996	11	
ST446	5	
90908	5	

PB67-43001-171 Mounting Plate		Manufactured	No			100	Each	164.0000	6	12		11/13/09.05	
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Location	Loc Qty	Loc Code
ST384	164	
90909	18	
99995	146	

8 7 6 5 4 3 2 1

ITEM	QTY -75	P/N	DESCRIPTION
1	X	B67-43001-75	LOWER BLADE SUPPORT ASSY
3	2	B67-43001-167	SIDE PLATE
4	1	B67-43001-169	LONG SUPPORT PLATE
5	6	B67-43001-171	MOUNTING PLATE
6	1	D3450-1	REINFORCEMENT PLATE
8	12	MS20426AD3-4	RIVET
9	6	MS21075L3	NUT PLATE



B67-43001-75 LOWER BLADE SUPPORT ASSY

RELEASED
2010-09-16

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 11 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.26
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	JIS	DRAWING NO.	REV. C	
MFG. APPR.	JIS	B67-43001-75	SHEET 1 OF 2	
APPROVED	JIS	TITLE	SCALE	
DE APPR.	N/A	LOWER BLADE SUPPORT ASSY	NTS	
DATE	09.06.26		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO DISSEMINATION OR REPRODUCTION OF THIS DOCUMENT IS PERMITTED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREEN SANDEXT" (4.3.5.8) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-75" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 2.20 lbs
 - 8) WELDING: PER DART QSI 004

8 7 6 5 4 3 2 1

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY												
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